

Date: Friday, 17/08/2007 11:21:57 AM
 User: Linda Lacelle

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|---------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : DUCT |
| Job Number | : 34104 | | |
| Estimate Number | : 12175 | | |
| P.O. Number | : N/A | Part Number | : D34761 |
| This Issue | : 17/08/2007 S.O. No. : N/A | Drawing Number | : D3476 REV A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : SMALL /MED FAB | Drawing Revision | : A |
| Previous Run | : 32051 | Material | : N/A |
| Written By | : <u>[Signature]</u> | Due Date | : 11/09/2007 |
| Checked & Approved By | : <u>9/07/08 20</u> | Qty: | 10 Um: Each |
| Comment | : Est Rev: A New Issue 06-02-03 JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-----------|---------------------|
| 1.0 | M304S26GA | 304/316 0.018 SHEET |
|-----|-----------|---------------------|



Comment: Qty.: 0.4374 sf(s)/Unit Total : 4.3743 sf(s)

304/316 0.018 SHEET

Batch: M105445 IB 07-08-29

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

Cut as per Dwg D3476

Dwg Rev: A

Prog Rev: A

IB 07-08-29

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 07-08-29

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

E 9/08/30

(X/D) count

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

2-Roll as per Dwg D3476

3-Spot weld as per Dwg D3476 and Dart QSI 018

} ml 07/09/04 x10

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 09/09/05
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:21:57 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUCT

Job Number: 34104

Part Number: D34761

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/09/05 10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/09/05 10

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57/60 CU 7/9/5 (10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(10) 07/09/05

Job Completion



CU 07/09/05

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

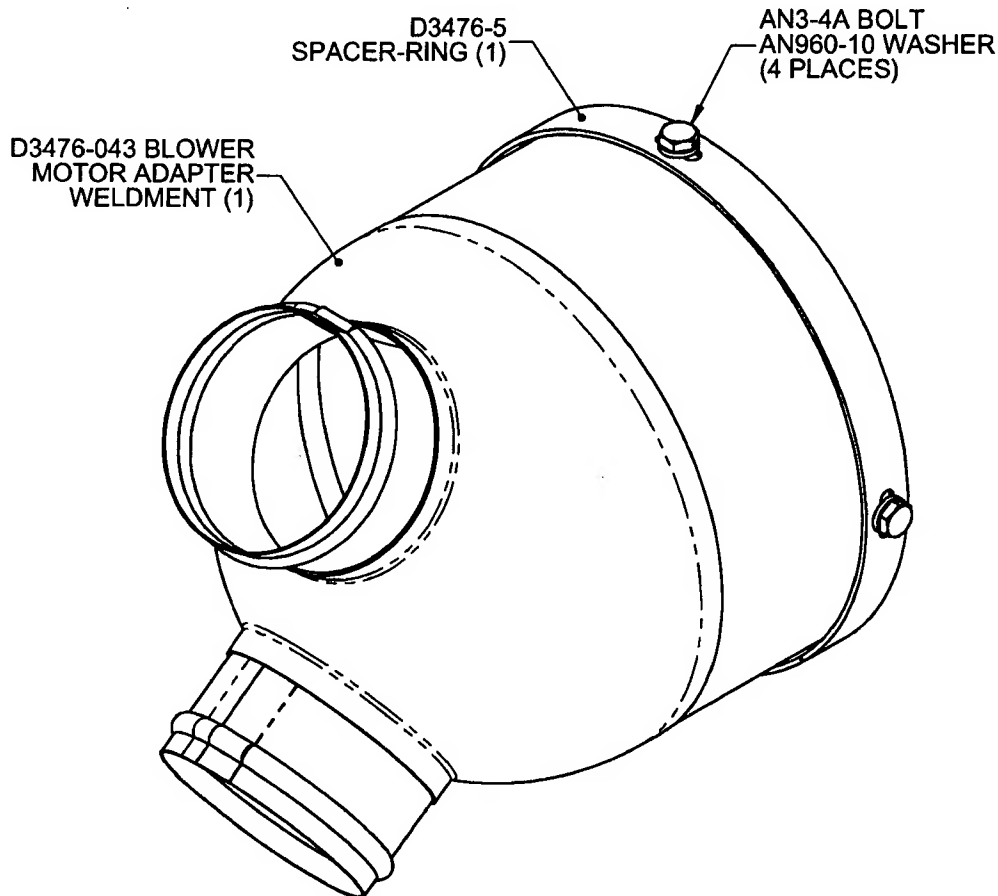
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|--|------------------------|
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3476 | REV. A SHEET 1 OF 7 |
| DATE 06.01.27 | | TITLE BLOWER MOTOR ADAPTER SCALE 1:2 | |
| A | 06.01.27 | NEW ISSUE | |

[Signature] 06.04.03



D3476-041 BLOWER MOTOR ADAPTER

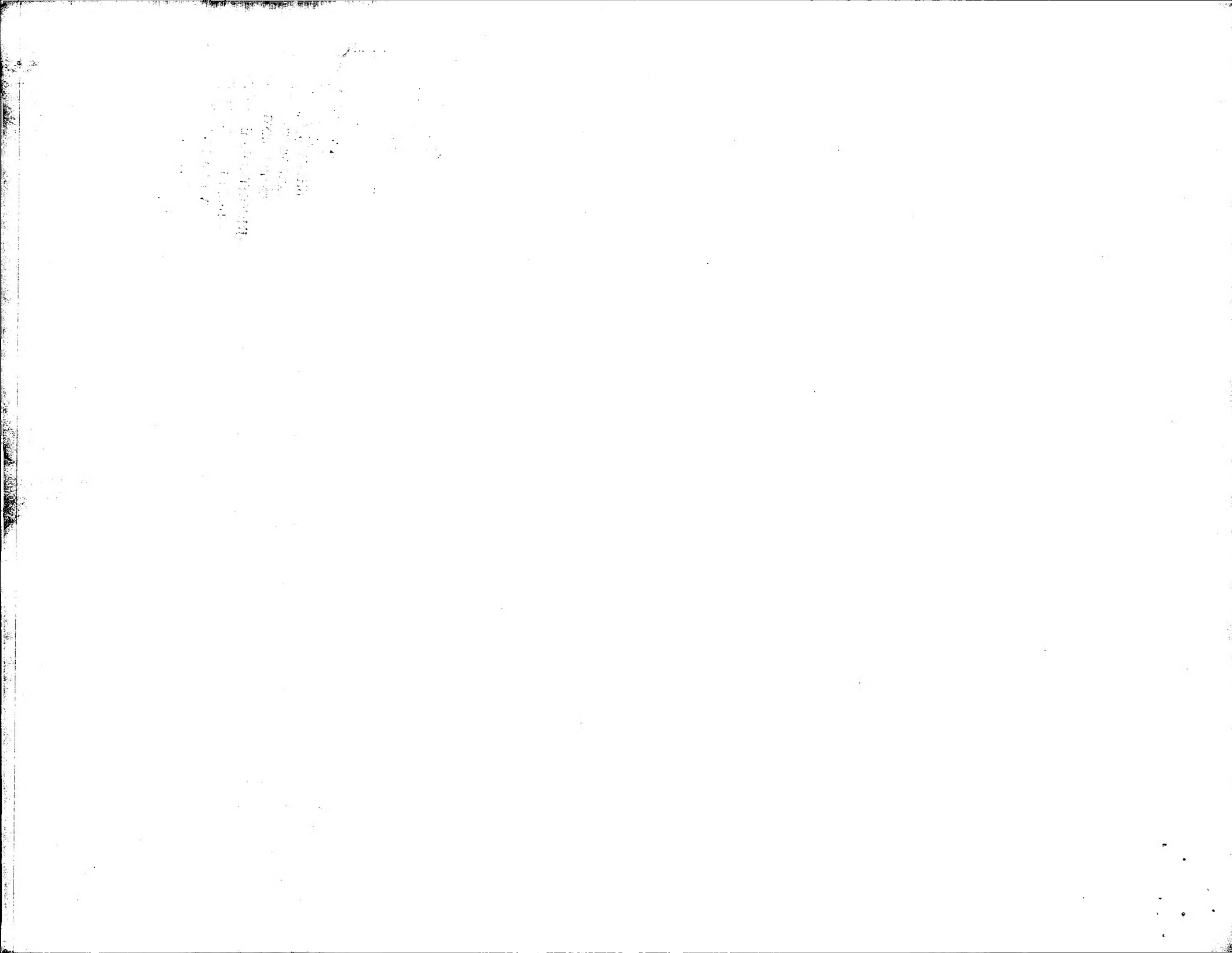
- 1) IDENTIFY WITH DART P/N D3476-041 USING FINE POINT PERMANENT INK MARKER

| QTY -041 | P/N | DESCRIPTION |
|-------------|-----------|-------------------------------|
| X | D3476-041 | BLOWER MOTOR ADAPTER |
| 1 | D3476-043 | BLOWER MOTOR ADAPTER WELDMENT |
| 1 | D3476-5 | SPACER-RING |
| 4 | AN3-4A | BOLT |
| 4 | AN960-10 | WASHER |

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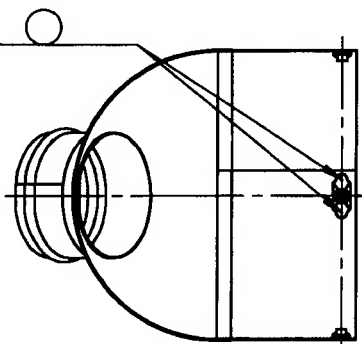
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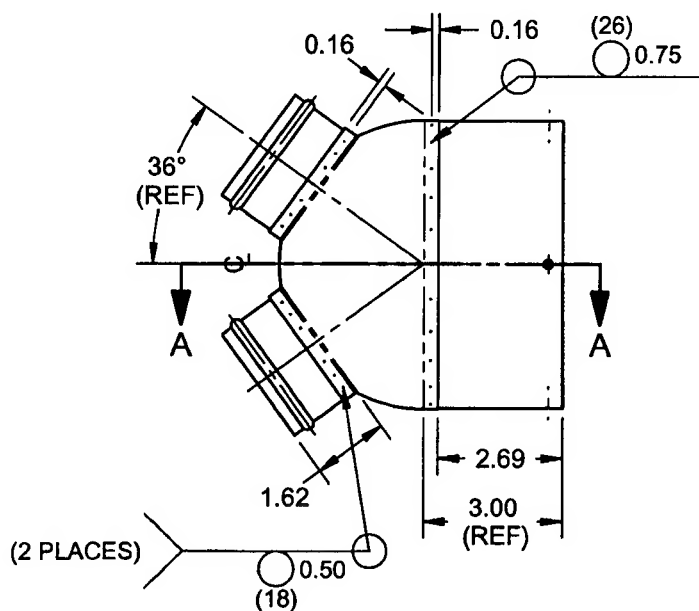
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| CHECKED # | APPROVED # | DRAWING NO. D3476 | REV. A SHEET 2 OF 7 |
| DATE 06.01.27 | | TITLE BLOWER MOTOR ADAPTER | SCALE 1:4 |

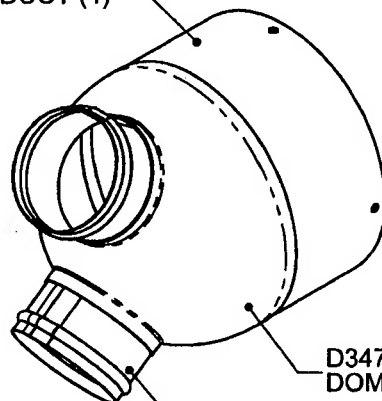
LOCATE AND
SPOT WELD
NUT PLATES
(4 PLACES)



SECTION A-A



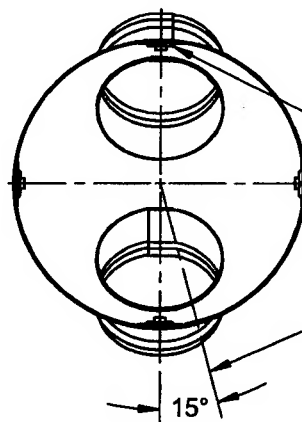
D3476-1
DUCT (1)



D3476-3
DOME (1)

D3476-7 TUBE
(2 PLACES)

NAS-1031C3W
NUT PLATES
(4 PLACES)



OFFSET SEAM
ON DUCT

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D3476-043 BLOWER MOTOR ADAPTER WELDMENT

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) PART IS SYMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

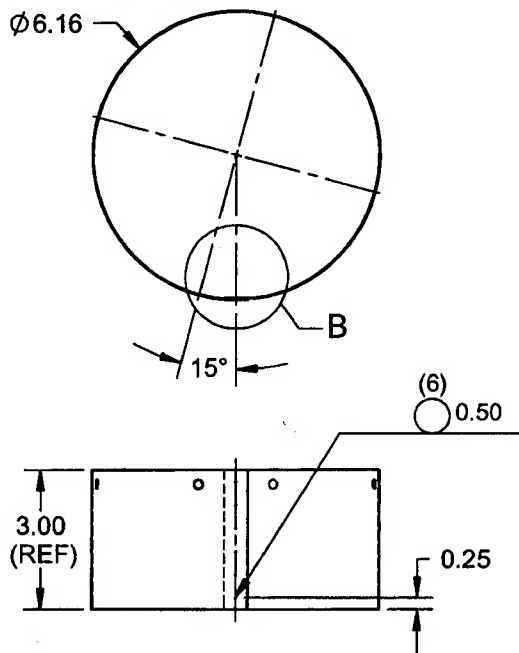
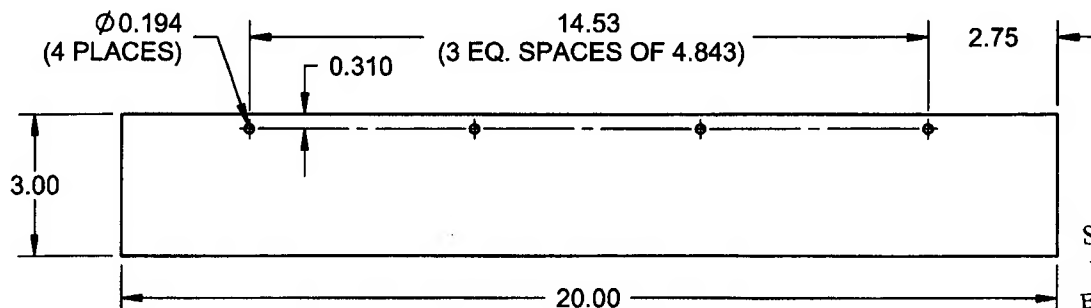
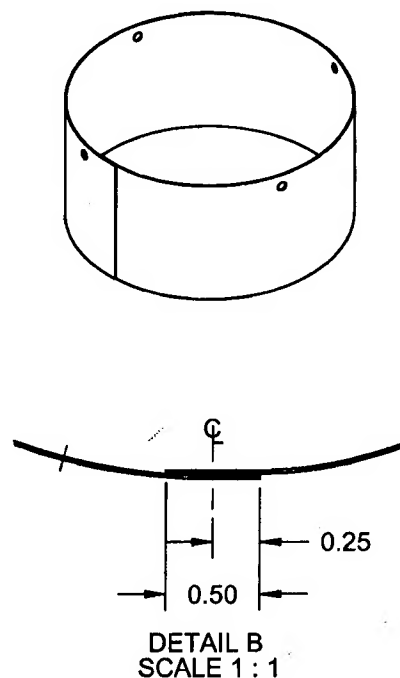
| QTY -043 | P/N | DESCRIPTION |
|-------------|------------|-------------------------------|
| X | D3476-043 | BLOWER MOTOR ADAPTER WELDMENT |
| 1 | D3476-1 | DUCT |
| 1 | D3476-3 | DOME |
| 2 | D3476-7 | TUBE |
| 4 | NAS1031C3W | NUTPLATE |

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| DATE 06.01.27 | | TITLE BLOWER MOTOR ADAPTER | SCALE 1:4 |

06.07.03**D3476-1 DUCT****D3476-1F DUCT FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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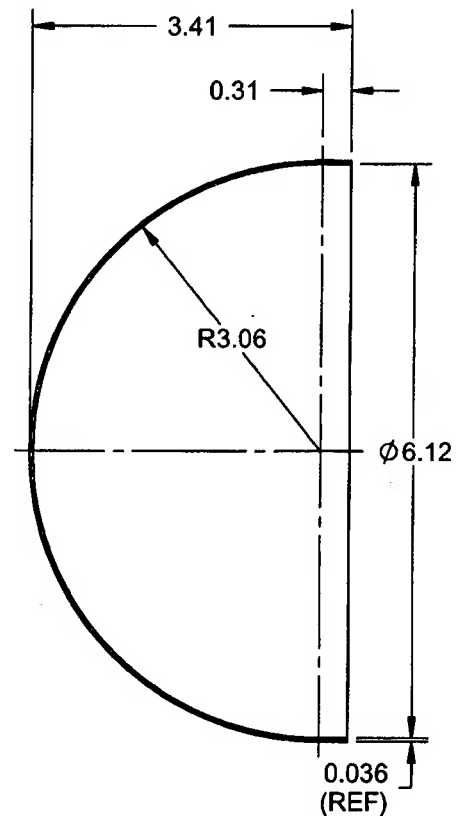
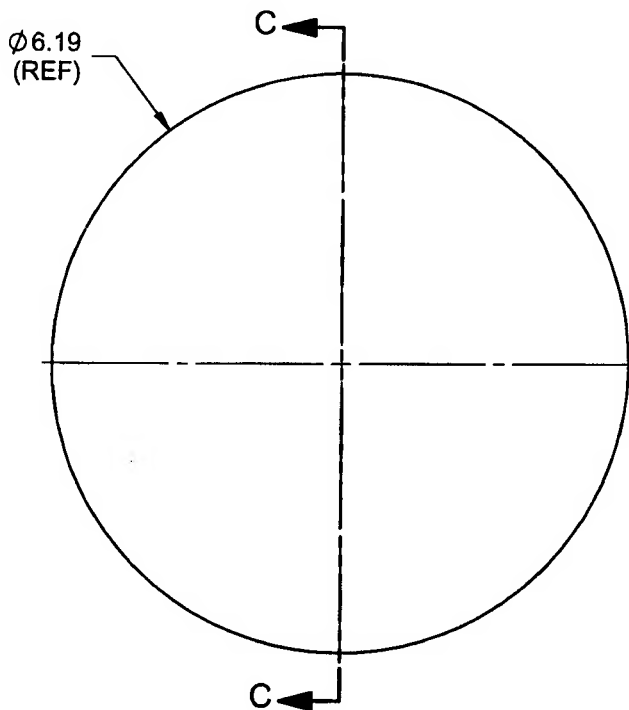
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| DATE 06.01.27 | | TITLE BLOWER MOTOR ADAPTER | SCALE 1:2 |

RELEASED

06.04.03 *[Signature]***SECTION C-C****D3476-3S DOME, SPINNING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.036 THICK PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S20GA)
- 2) FORM BY SPINNING TO DIMENSION WITHOUT EXCESS THINNING OF MATERIAL (MINIMUM THICKNESS = 0.025").
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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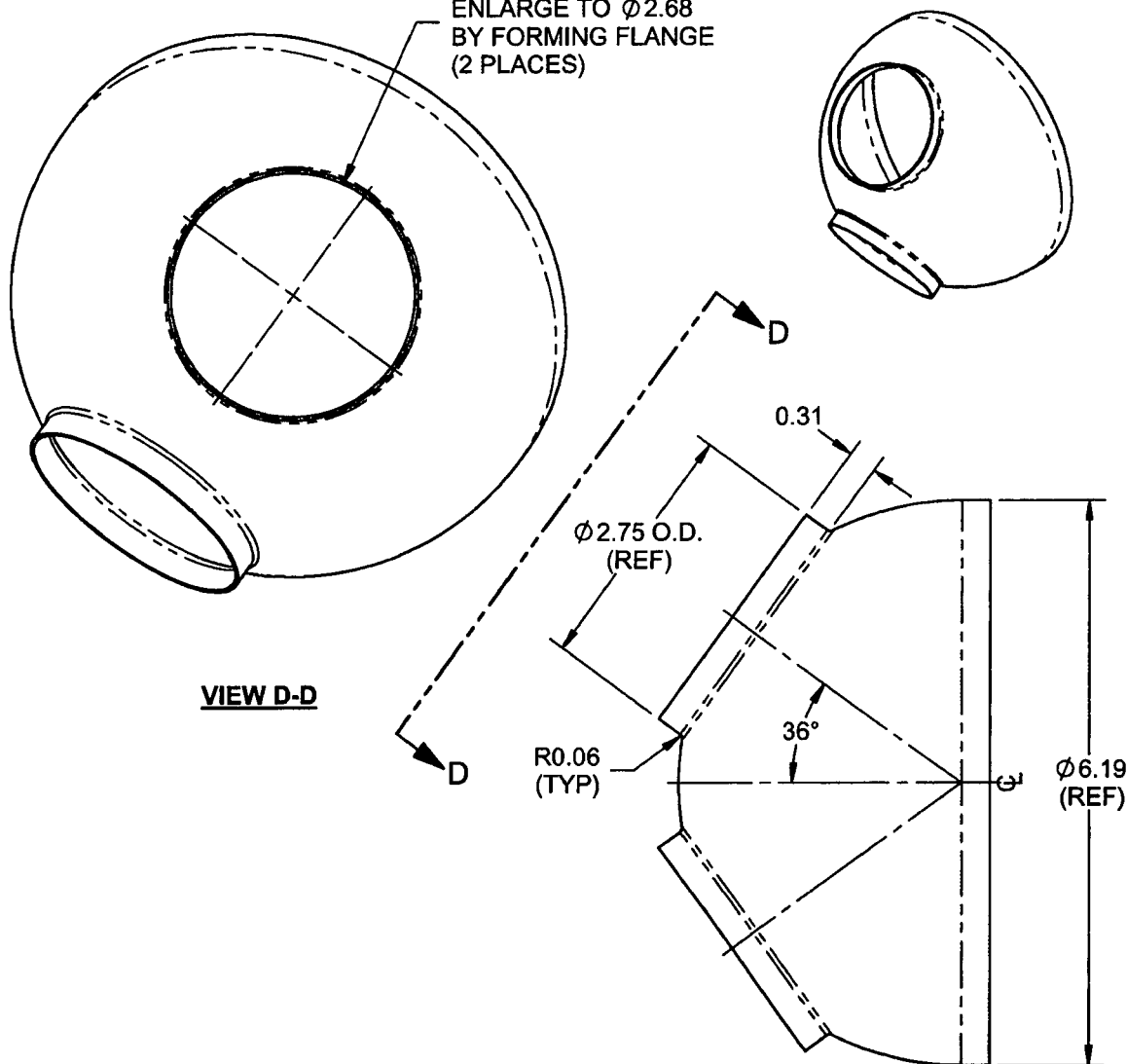
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| DATE 06.01.27 | | TITLE BLOWER MOTOR ADAPTER | SCALE 1:2 |

06.04.03

CUT $\phi 2.25$ HOLE,
ENLARGE TO $\phi 2.68$
BY FORMING FLANGE
(2 PLACES)



D3476-3 DOME

NOTES:

- 1) MATERIAL: MAKE FROM D3476-3S
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

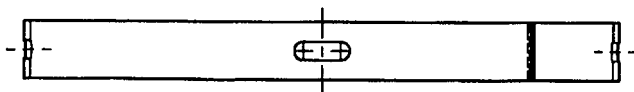
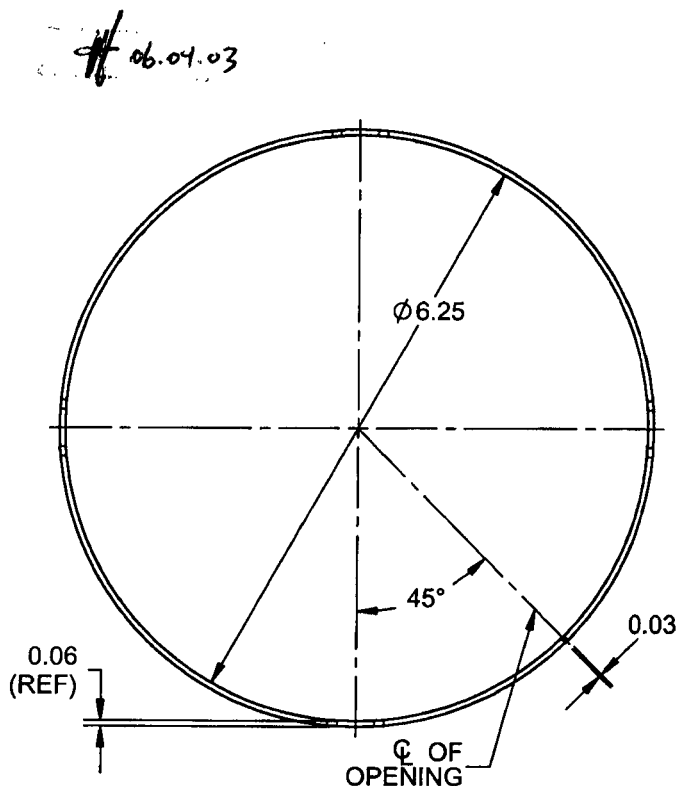
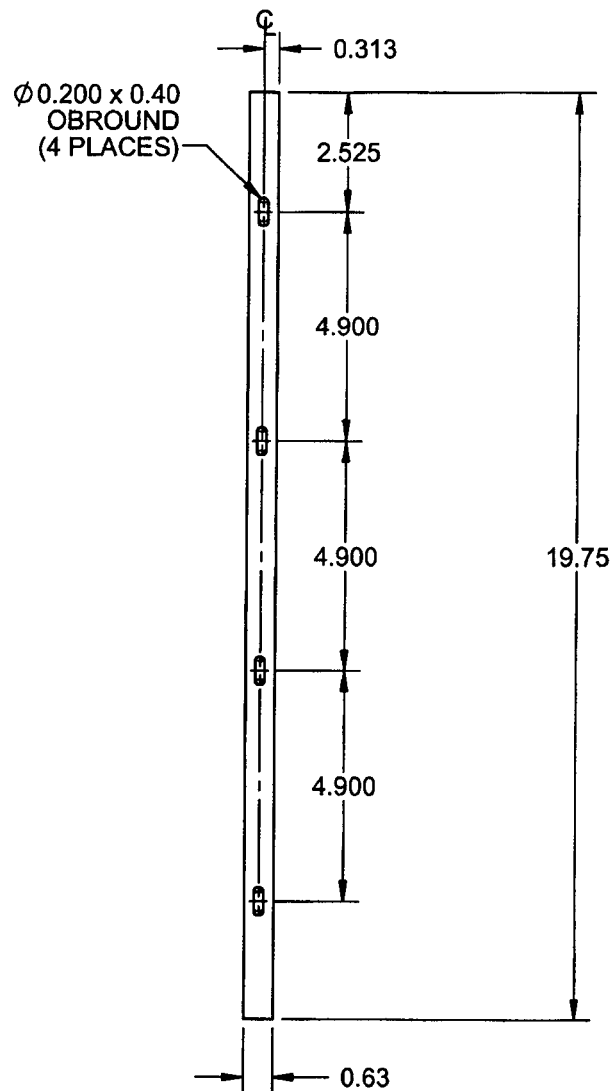
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| CHECKED <i>#</i> | APPROVED <i>#</i> | DRAWING NO. D3476 | REV. A SHEET 6 OF 7 |
| DATE 06.01.27 | | TITLE BLOWER MOTOR ADAPTER | SCALE 1:2 |

**D3476-5 SPACER-RING****D3476-5F SPACER-RING**
FLAT PATTERN**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

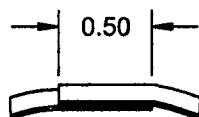
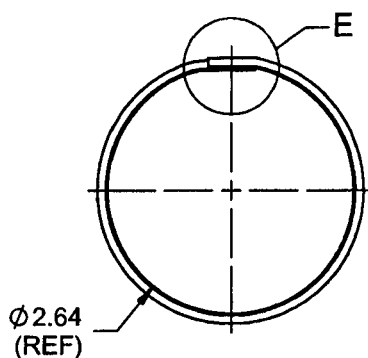
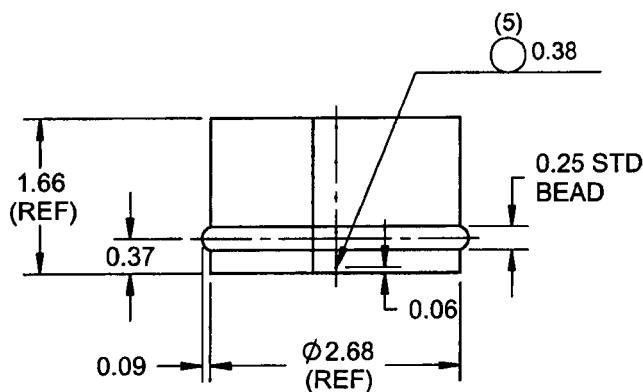
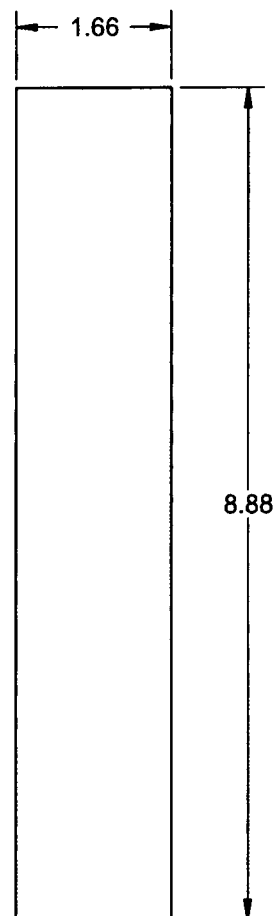
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3476 | REV. A SHEET 7 OF 7 |
| DATE 06.01.27 | | TITLE BLOWER MOTOR ADAPTER | SCALE 1:2 |

[Signature] 06.04.03DETAIL E
SCALE 1:1**D3476-7 TUBE****D3476-7 TUBE
FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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10-54

SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 1

EMPLOYEE: Manique Lepage

PART NUMBER: D 3476-1

JOB NUMBER: 34104

MATERIAL TYPE: 304 1018 sheet

MATERIAL THICKNESS: 0.11

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium

TEST RESULTS

| | PASS | FAIL |
|----------------|--------------|------|
| VISUAL: | [<u>/</u>] | [] |
| PENETRATION: | [<u>/</u>] | [] |
| PULL STRENGTH: | [<u>/</u>] | [] |

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/09/04

QUALIFIER: JB